

Work Order ID 50502

July 10, 2009 2:52:07 PM

Need drugs



Page 1

Item ID: D3963-3KIV

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Light Cover

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3963

A-PROTO

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

*BB 09/07/15 (X1)
M109703*

110

0.00



Thermoform

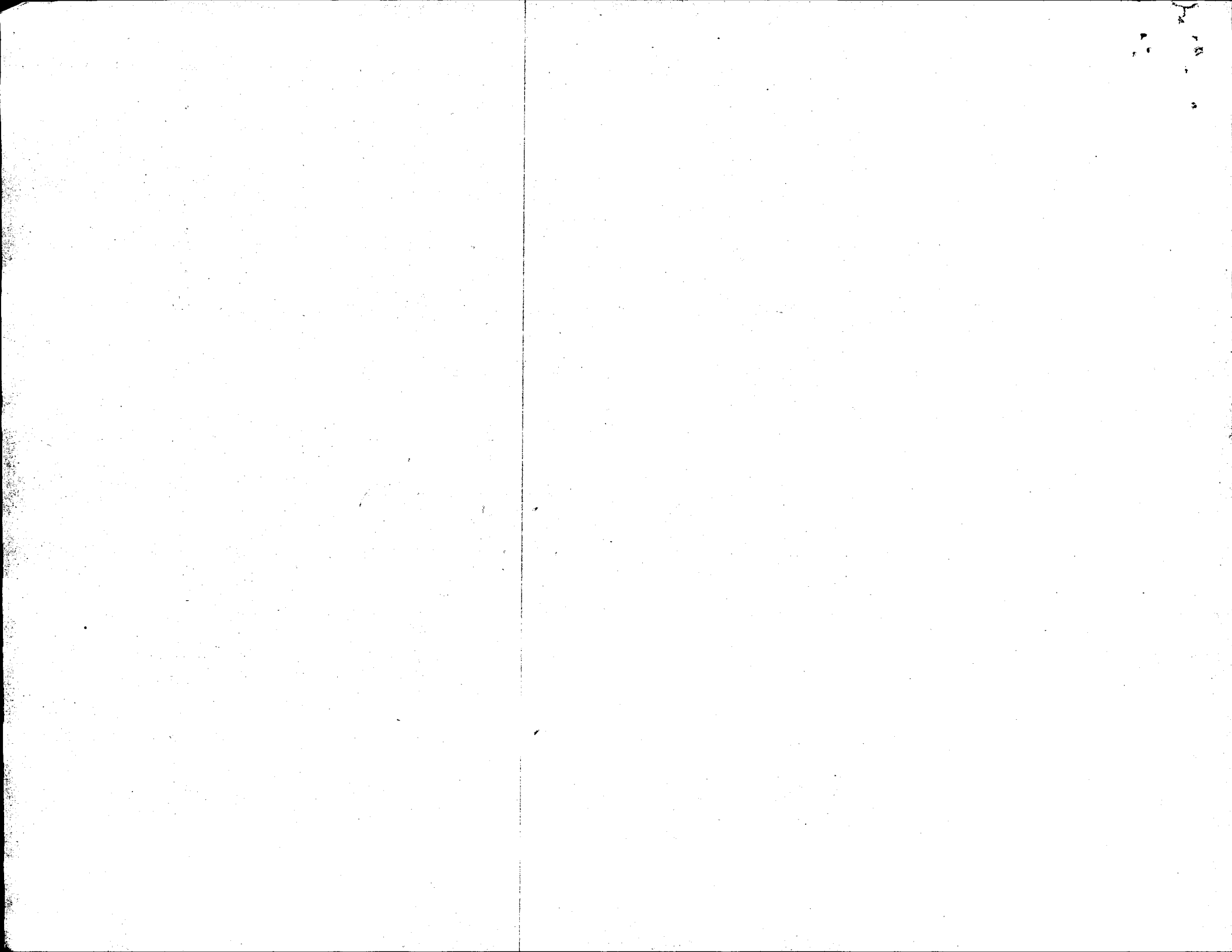
Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA064 using tool DT9xxx
Dwg Rev: *BB*
Folio Rev: *BB*

BB 09/07/15 (X1)



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Cust Item ID:

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

BB 07/07/15 XI

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

BB 07/07/16 XI

140

0.00



Hand Thermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

BB 07/07/15 XI

Work Order ID 50502

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Page 3

Item ID: D3963-3KIV

Accept



Setup Start



Revision ID: A-PROTO

Item Name: Light Cover

Stop



Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

09/07/15 XI

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

09-07-20

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

FOR ENG'G TEST 09-07-20

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Item ID: D3963-3KIV

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Light Cover

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

RD0303
u 8-09-28 R

Picklist Print

July 10, 2009 2:52:06 PM

Page 1

Work Order ID: 50502

Parent Item: D3963-3KIVRevA-PROTO

Parent Item Name: Light Cover

Comments:

Start Date: 07/13/2009

Required Date: 07/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	894.5038	0.5938			



6185 KYDEX .080"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

894.5037653

109703

894.503765

M109703

BB 09/07/15

27x21 ÷ 5

W/O 50491

500

501

503

20641 11900

DART AEROSPACE LTD		Work Order: 50502
Description: LIGHT COOR		Part Number: D3963-2KIU
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

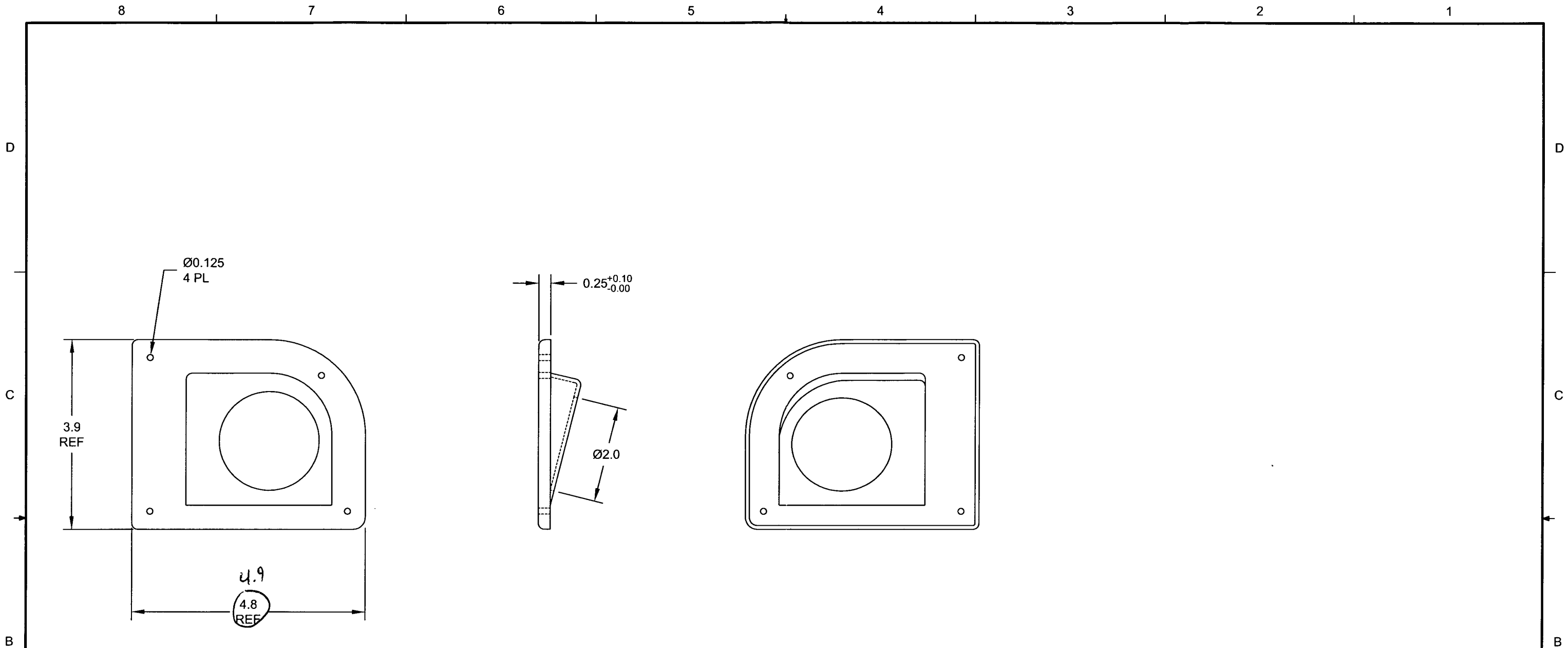
Measured by: BB Date: 09/07/16

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.25	$\pm .10$.280	✓			
4.9		4.9	✓			
3.9		3.9	✓			
2.0		1.996	✓			
.050	reference	.063	✓			
0.44	0.45	0.43	✓			
0.50	0.51		✓			
0.33	0.37		✓			
0.75	0.75		✓			
φ0.125	± 0.005	φ0.125	✓			

Measured by: BB Date: 09/07/16
Audited by: PL Date: 09.07.17
Prototype Approval: PL Date: 09.07.17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



D3963-2 LIGHT COVER

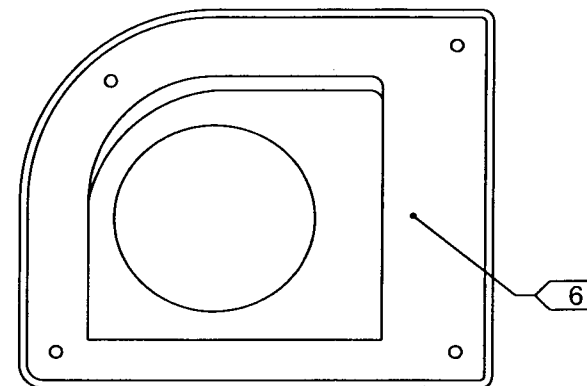
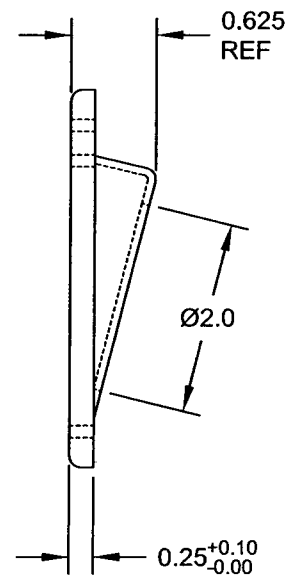
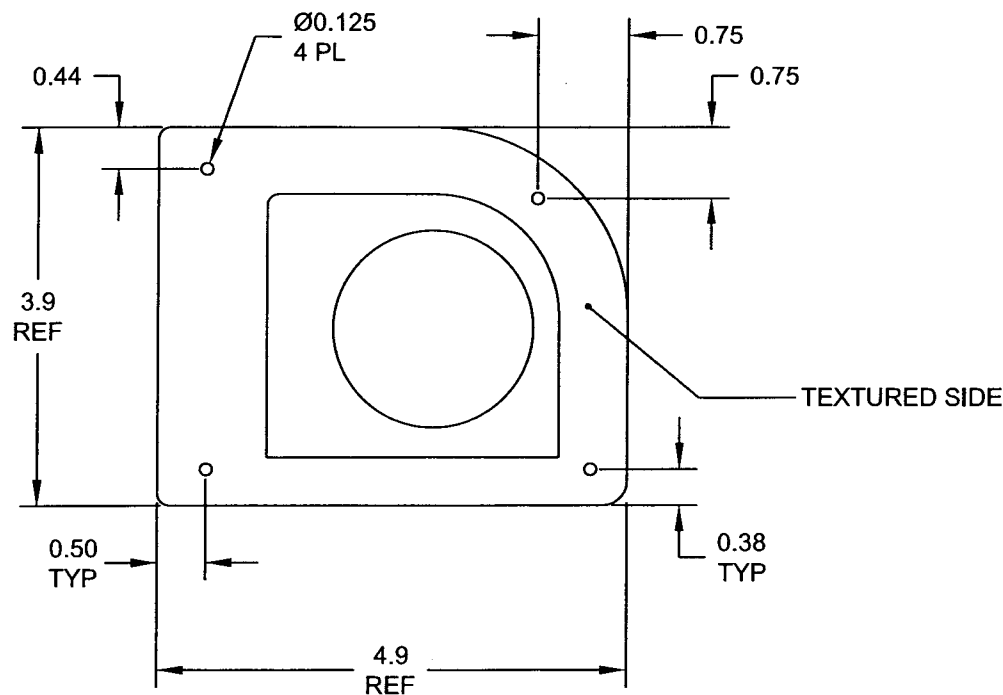
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09.07.16 *[Signature]*

50502

- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: 0.08 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9356 PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3963-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3963-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3963	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LIGHT COVER (206 L3/L4)	NTS
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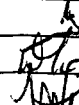


D3963-3 LIGHT COVER

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.08 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9356 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.030" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3963-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3963-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PA	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RE		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3963	SHEET 2 OF 2
APPROVED		TITLE	SCALE
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